

Date: Thursday, 05/02/2009 3:47:28 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPACER
Job Number : 45568	
Estimate Number : 12481	
P.O. Number :	Part Number : D35201
This Issue : 05/02/2009 S.O. No. :	Drawing Number : D3520 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 37623	Material :
Written By :	Due Date : 03/03/2009 Qty: 20 Um: Each
Checked & Approved By : <u>JW 09.02.09</u>	
Comment : Est Rev:A New Issue 06-06-28 JLM est rev B rev a dwg 07.04.09 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X01000	6061-T6 Bar .500 x 1.00
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Comment: Qty.: 0.1218 f(s)/Unit Total : 2.4360 f(s)
 6061-T6 Bar .50" x 1.0"
 (M6061T6B0500X1000)
 Batch: M107436

J.F. 09/02/09 (20)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut Blanks 1.400" long

J.F. 09/02/09 (20)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA646 Rev: AA & Dwg D3520 Rev: A

2-Deburr per dwg D3520

J.F. 09/02/09 (20)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 09/02/09 (20)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.F. 09/02/10 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M

09-02-10

(20)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M109996

START TIME:

13:45

OVEN TEMPERATURE:

320°

FINISH TIME:

14:15

BL

09-02-13

(20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M. L

09/02/13

(20X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

100

9/2/16

(204)

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/18

Job Completion



MF
09-02-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

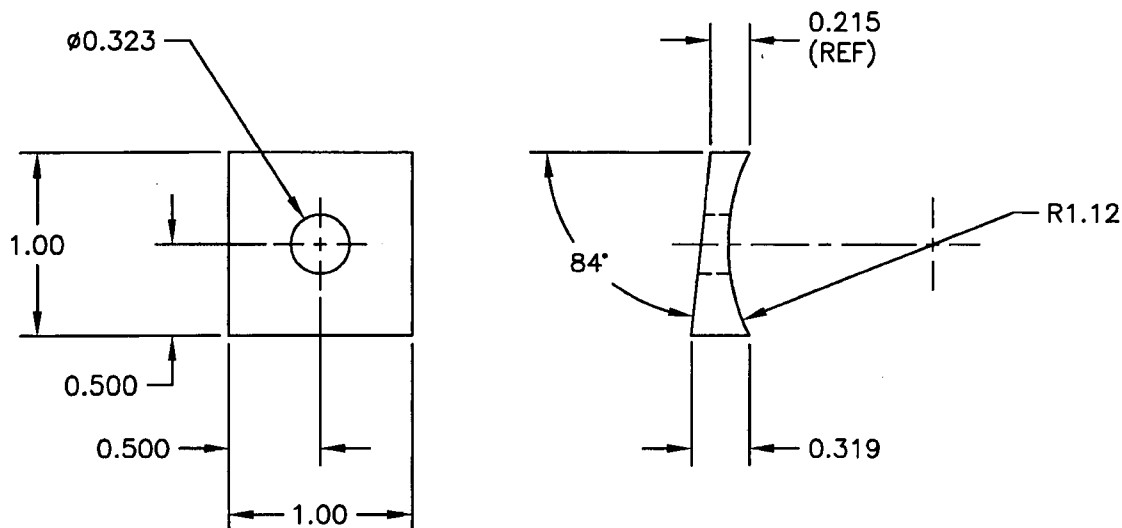
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3520	REV. A SHEET 1 OF 1
DATE 06.06.28		TITLE (A119 BASKET) SPACER SCALE 1:1	
A	06.06.28	NEW ISSUE	

RELEASED

06.11.17 *[Signature]***D3520-1 SPACER**

- 1) MATERIAL: M6061-T6 (OR 6061-T651/T6510/T6511/T6512/T62) ALUMINUM
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF DART MATERIAL SPEC M6061T6B)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45568

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